

Date: Tuesday, 3/11/2008 7:57:24 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END CAP
Job Number : 37743	
Estimate Number : 11877	
P.O. Number :	Part Number : D2208
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2208 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 35095	Material :
Written By :	Due Date : 3/25/2008 Qty: 20 Um: Each
Checked & Approved By : <u>AS 080311</u>	
Comment : Est A 01.03.08 New Issue	
Est B 07.09.11 ecn 998 EC verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.1531 sf(s)/Unit Total : 3.0618 sf(s)
 6061-T6 .063 Sheet
 5052-H32 or 6061-T6 - .063" Thick
 Batch 105225 B 8-3-18

2.0	WATER JET	FLOW WATER JET
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PD

Comment: FLOW WATER JET
 1-Cut as per Dwg D2208
 Dwg Rev: C
 Prog Rev: C

B 8-3-18

20

2-Deburr if necessary B 8-3-18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-3-18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

AS 08/03/18 X20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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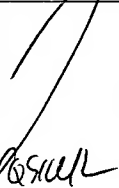


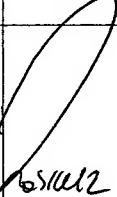

Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: DAT Dnal

AS 08/03/18 X20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 22208 PAR #: N/A Fault Category: Prod / Eng' ASS' med & small NCR: Yes No DQA: Y Date: 08/03/20
 QA: N/C Closed: Y Date: 08/03/24

NCR: 37743		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/18	2.0	See all 20 parts are too long - by 0.020" over nominal. R.C. Self offset / Hummer error		Scan all 20 parts Replace B# <u>IB 105205</u> see ncr # 08-025	 8-3-18	 08/03/18	 JSU/L	 08/03/18

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:24 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 37743

Part Number: D2208

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Done 03/20

Job Completion



mi 2008/3/20

(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

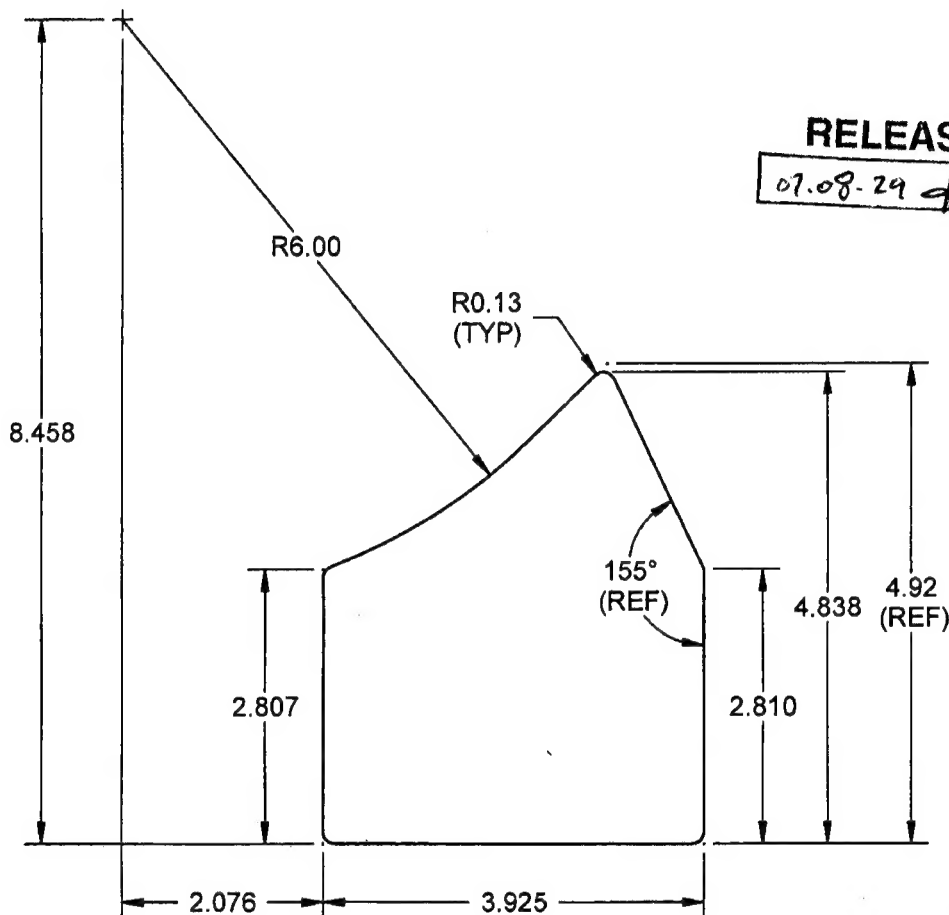
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD BURLINGTON, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	D2208	REV. C SHEET 1 OF 1
DATE 07.07.05		TITLE END CAP SCALE 1:2	
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.22	REDRAWN	
C	07.07.05	REDESIGN	

**D2208 END CAP****NOTES:**

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **37743**

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DART AEROSPACE LTD		Work Order:	37743
Description: END CAP		Part Number:	D2208
Inspection Dwg: D2208 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	BB	Audited by:	J	Prototype Approval:	n/
Date:	8-3-18	Date:	08/03/18	Date:	1/4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	